

Work Order ID 143829 - 1

143829

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Wednesday, March 23, 2016 9:51:21 AM

Item ID: D3787-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Foot
 Start Date: 3/28/2016 Start Qty: 24.00 *24*
 Required Date: 4/14/2016 Req'd Qty: 24.00 *24* 21x
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3787	Rev A

100	PURCHASING	0.00				24		MAR 24 2016	DAS 13 9-89
100	Memo	0.00							
Purchasing	Issue P/O: 31819 Purchase Part Number: MS22034-1B or BHT P/N 205-070-786-001 Supplier: AUTO PARTS (P/N: 32334) Certificate of conformity is required								
Purchasing									

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110	Memo	0.01							
Packaging	Ensure Material Release Note is attached								
Packaging									

21x 8p16-04/15

120	QC6- Inspect dimensions to drawing	0.00							
120	Memo	0.00							
QC									
Quality Control									

(21)

DAS
38
9-89
APR 18 2016

FILE 10019

10019

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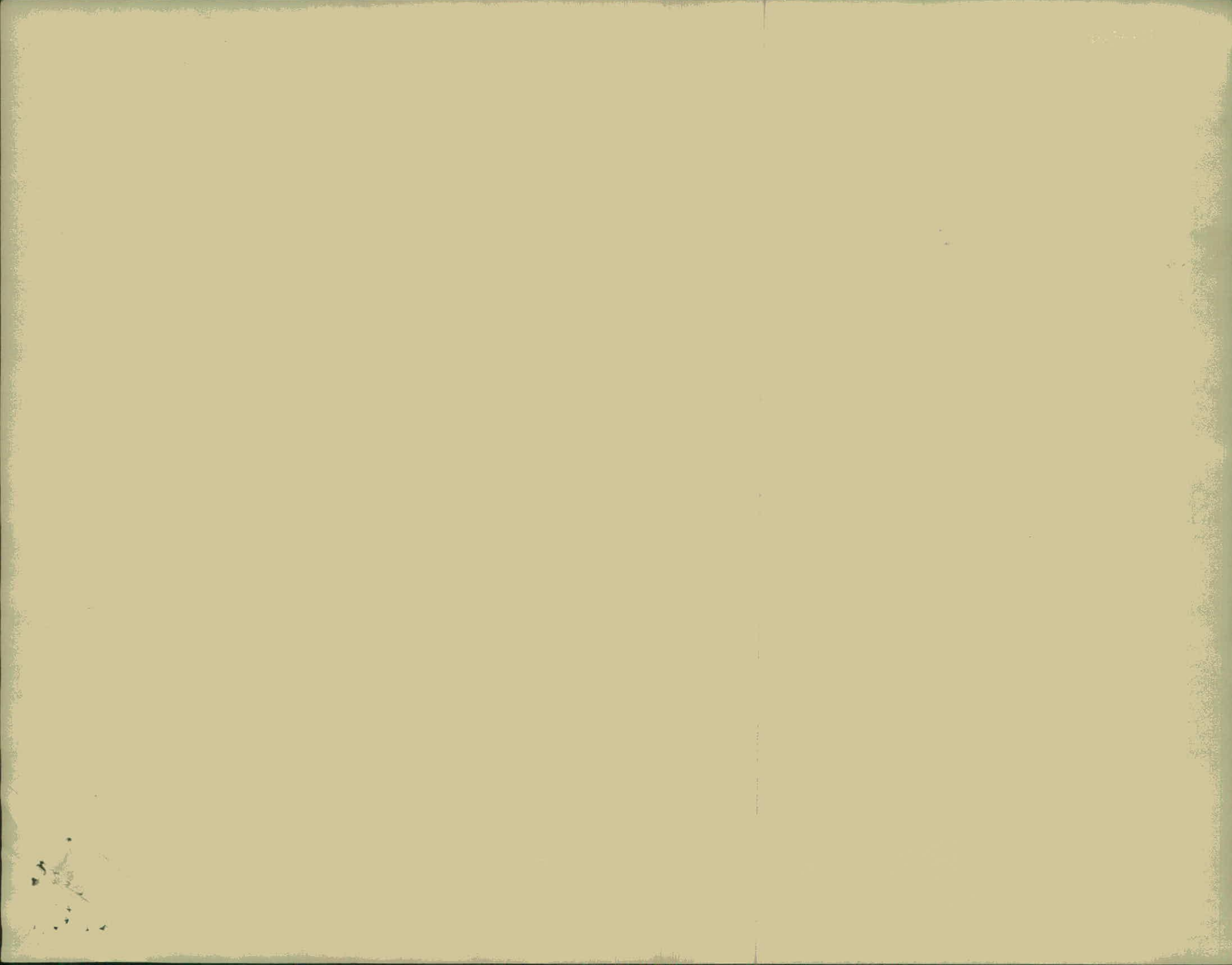
143829

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Item ID: D3787-1 Accept ***N900040100*** Setup Start ***NS1***
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo 1- Drill hole to finish size as per dwg D3787 2- Deburr hole as per dwg D3787	0.00 0.04				17	4		J.C.L. 16-04-19
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				(17)			DAS 38 9-89 APR 19 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>St253</u> Memo	0.00 0.00				17			DAS 8 9-89 APR 20 2016



DQA:

Date: 16.05.10

QA Closed: ~~16/04/27~~ Date: 16/04/27Work Order update only ☐

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: 143829

Part No. D3787-1

NCR No. 16-5744

DISPOSITION

Rework ☐Scrap ☒Use-as-is ☐Suspected Unapproved ☐Skid-tube ☐Machining ☒Thermoforming ☐Large Fab ☐

AGAINST DEPARTMENT/PROCESS

Cross tube ☐Small Fab ☐Finishing ☐Composite ☐Water Jet ☐Prod. Eng. Coord. ☐Rec/Store/Packaging ☐Supplier ☐Engineering ☐Quality ☐Other ☐

Date: 16-04-19

Step #: 130

QTY Effective: 4

MRB (QSI042) Approval

DAS
9
9-89

16-04-19

Completed By

J.C.L. 16-04-19

Lead hand / Supervisor
Approval VerificationDAS
08
9-89
J.A. 16/04/19QC / QA Coordinator
ApprovalDAS
9
9-89
16-04-19

Description Work Order Deviation

The 0.323 hole is supposed to be at 90° from pin but is drilled at 0°

RC operator

Disposition

Scrap + destroy
no replace

Root Cause

Environment ☐Design ☐Doc/Data ☐Equip/Tooling ☐Handling/Pre ☐Material ☐Internal Transport ☐Tribal Knowledge ☐LOA ☐Substation ☐Past Expiry Date ☐Misidentified ☐☒ No Re-verification☒ Operator☐ Offset/Setup☐ Supplier☐ Training☐ Use for Testing☐ Poor Information☐ Rushing☐ Product Improvement☐ Process Improvement☐ Manufacturing Process☐ Past Due☐ Pressure/Forced☐ Bending☐ Centre Not Concentric☐ Cracks☐ Crimp/Kink/Ripple/Wave☐ Cuffs☐ Crushing☐ Heat Treat☐ Wave/Twist in Tube☐ Marks/ChatterOTHER: ☐

FAULT CATEGORY

☐ Temperature/Cure☐ Set-up☐ BOM/Route☐ Broken/Damage/Defect☐ Inspection Incomplete/Unqualified☐ Contamination☐ Countersink☐ Cut Too Short☐ Instructions Incomplete/Unclear☒ Drill Holes☐ Power Loss/Surge☐ Folio/Program☐ Grain☐ Weld☐ Wrong Stock Pulled☐ Out of Sequence☐ Off-set☐ Misabeled☐ Fit/Function☐ Misaligned/off center☐ Positioned Wrong☐ Outside Dimensions☐ Over/Under tolerance☐ Part Incorrect☐ Part Lost/Missing☐ Part Moved☐ Drawing☐ Finish☐ Misread☐ Turning Sequence

10-6-11

10-6-11

1871

Work Order ID 143829***143829***

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							APR 21 2016
160									
QC	Memo	0.04							
Quality Control									

APR 21 2016



Picklist Print

Wednesday, March 23, 2016 9:51:20 AM

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Work Order ID: 143829

143829

Parent Item: D3787-1

D3787-1

Parent Item Name: Foot

Start Date: 3/28/2016

Required Date: 4/14/2016

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A 08-05-20 new issue DD verified by: LL
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS22034-1B		Purchased			No		Each	0.0000		24			

MS22034-1R

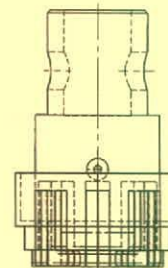
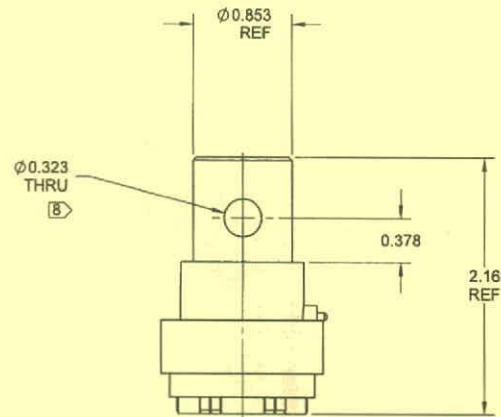
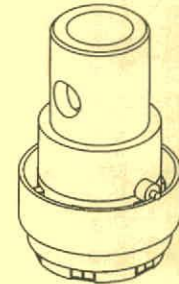
ADAPTER,QUICK DISCONNECT

**

~~2x 8/16 ALB.~~

21x 8/16 ALB.

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	MILITARY PART NUMBER	BHT PART NUMBER	STUD DIAMETER	FOOT HEIGHT
D3787-1	MS22034-1B	205-070-786-001	Ø0.853	2.16

D3787-1 FOOT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs
- 8) DRILL Ø0.323 HOLE 0.378 FROM SHOULDER, TOUCH UP WITH ALODINE AFTER DRILLING

N/A, PART IS ANODIZED.

DAS
22
9-89

16.04.20

160415829

RELEASED
08.06.15

REV.	A	NEW ISSUE	HS	08.06.04
DESIGN	HS	DESCRIPTION	BY	DATE
DRAWN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	PL	DRAWING NO.	REV. A	
MFG. APPR.		D3787		SHEET 1 OF 1
APPROVED		TITLE	SCALE	
DE APPR.		FOOT	NTS	
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

240
25
26



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31819

Purchase Order Date 3/24/2016 1:36:28 PM
PO Print Date 3/24/2016

Page Number 1 of 1

Order From :

B C INDUSTRIAL
14 OLD FOREST
KIRKLAND, QUEBEC H9J 2Z8

VC-BCI001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

Contact Name

Vendor Phone 514-585-8907

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

Terms

Currency

FOB

10127-2607

Net 30

CAD

FCA - (Free Carrier)

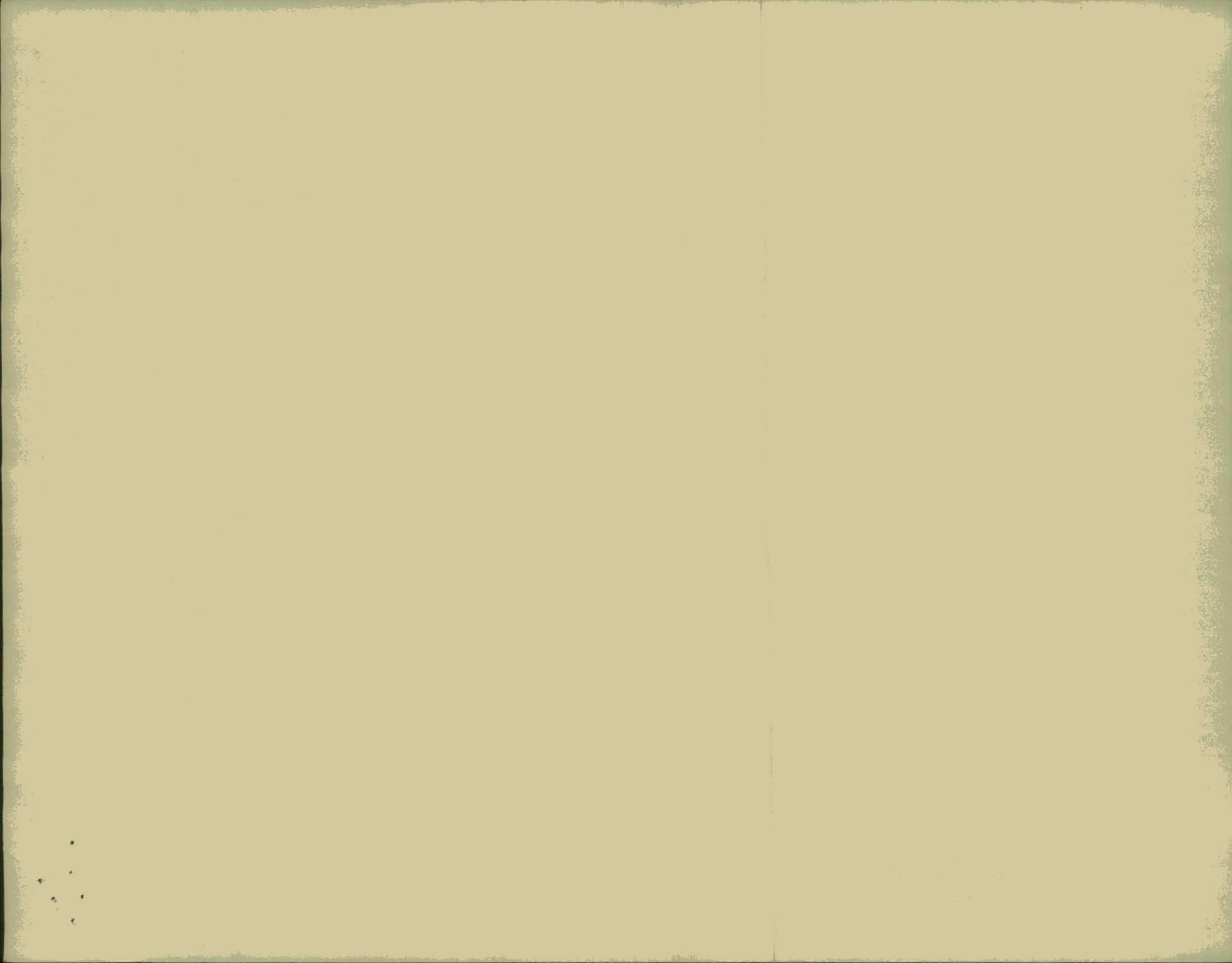
MAR 24 2016

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	MS22034-1B AS PER DWG D3787 REV. A B143829	ADAPTER,QUICK DISCONNECT	4/12/2016 Yes 4/15/2016		24.00 Each	\$69.95	\$1,678.80
Line Total:							\$1,678.80
2	71401-45 Procurement Quality Clauses A005 RIGHT OF ENTRY A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS	PROCUREMENT QUALITY CLAUSES	4/19/2016 No 4/19/2016		1.00	\$0.00	\$0.00
Line Total:							\$0.00
PO Total:							\$1,678.80

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 3/24/2016



DATE Apr 12 2016

Packing Slip

PS160412DA-1

Livrer a/Ship to:

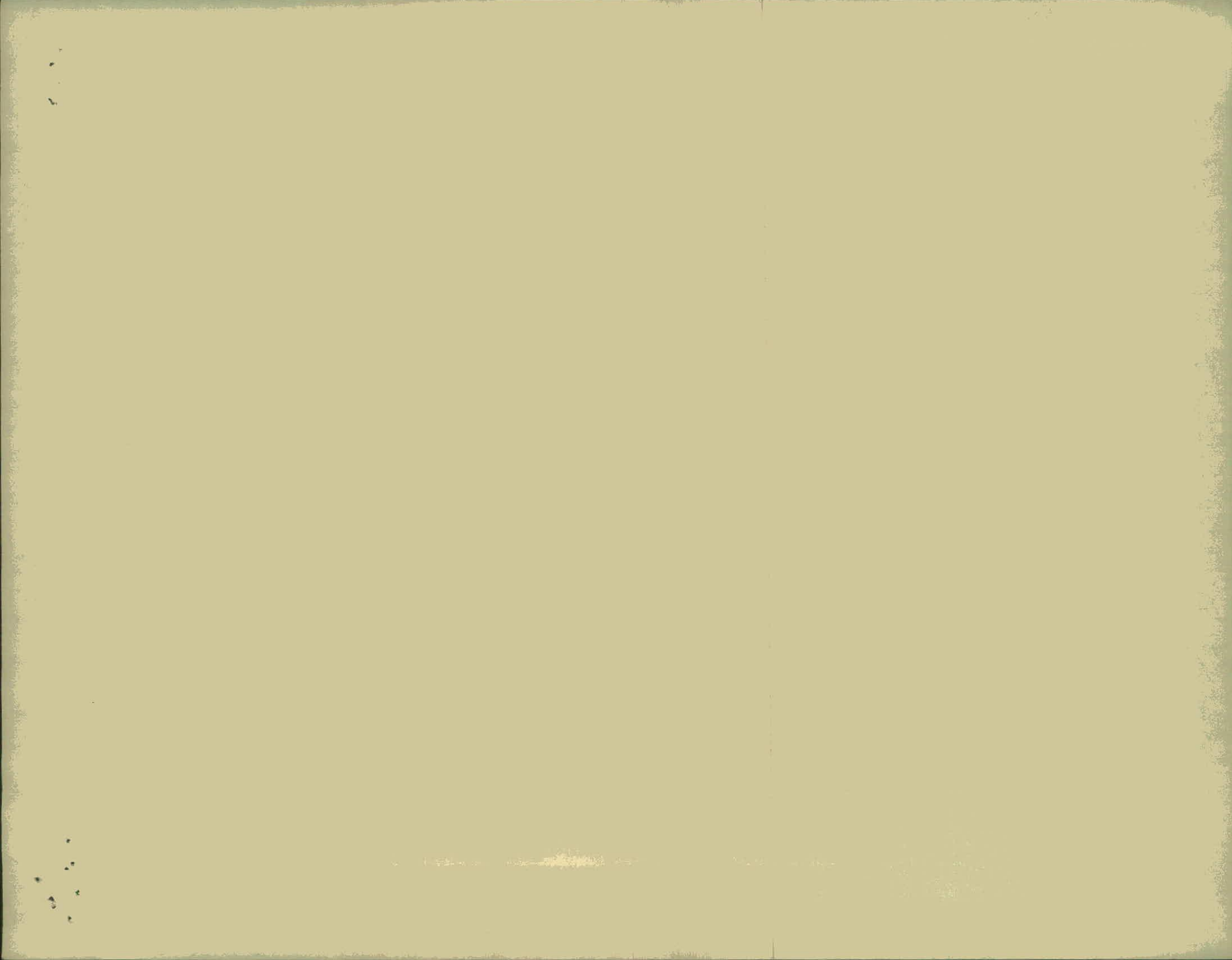
Dart Aerospace
1270 Aberdeen Street
Hawkesbury, Ont
K6A 1K7

PO 31819 ✓

	Description	Livrer/ship	B/O
1.	MS22034-1B quick connect Kinedyne part # 32340	21 ✓	3
2.			
3.			
4.			
5.			
6.			
7.			

Sp16 04-15

BC Industrial..14 Old Forest..Kirkland..Quebec..H9J-2Z8
Phone 514-585-8907 bcpc1@videotron.ca



BC Industrial..... 14 Old Forest....Kirkland....Quebec....H9J-2Z8....Canada
Phone 514-585-8907 Email bcpcl@videotron.ca

Certificate of Compliance

Apr 12 2016

Dart Aerospace
1270 Aberdeen
Hawkesbury, Quebec
K6A-1K7

ATT: Chantal Lavoie

This is to confirm that the parts delivered on our PS 160412DA-1

Quick connector MS22034-1B
Kinedyne # 32340

conforms to the specifications outlined on your purchase
order 31819

Thank you

Bryan Cameron

#TPS/GST-142640622
#TVQ/PST-1021696907

Terms 2%10 Net 30

